

## CLAIMS

1. An apparatus for glueing two webs (3, 4) of packaging material for the production of liquid-tight packs, in particular for liquid foods, wherein each web (3, 4) is covered at least at one side with a liquid-tight adhesive layer (58, 65) which can be activated by heat, comprising  
5        clamping means (5, 21, 27) for clamping the material webs (3, 4) fast,  
      a cutting unit (11) for applying an inclined cut (16) extending substantially transversely with respect to the material web (3, 4), and  
      a welding unit (30) for applying heat and pressure for glueing the material webs (3, 4) along  
10    an adhesive strip (29), characterised in that the welding unit (30) has a slider (31) which is displaceable along a transverse rail (28) substantially transversely with respect to the direction of travel (9) of the material web (3, 4) and on which are arranged a heating means (33) and therebehind in the direction of displacement (20) a pressure roller (38).
- 15        2. Apparatus according to claim 1 characterised in that a cutting blade (40) is arranged on the side opposite to the pressure roller (38) with respect to the heating means (33).
3. Apparatus according to claim 1 or claim 2 characterised in that arranged on the slider (31) beside the pressure roller (38) is a guide element (41) for lifting the material web (34) along its transverse edge (18) during the displacement of the slider (31).  
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4. Apparatus according to one of claims 1 to 3 characterised in that the heating means (33) has a hot air element (34), a transfer tube (35) and a hot air nozzle (36), preferably in the form of a wide-slot nozzle.  
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5. Apparatus according to one of claims 1 to 4 characterised in that the welding unit (30) and the transverse rail (28) can be raised and lowered in the lifting direction (8) substantially perpendicularly to the direction of travel (9) of the material web (3, 4) and perpendicularly to the direction of displacement (20) of the slider (30).  
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6. Apparatus according to one of claims 1 to 5 characterised in that fixed under the transverse rail (28) are a first clamping bar (27) and at a spacing therebeneath a second clamping bar (27).
- 35        7. Apparatus according to one of claims 1 to 6 characterised in that the pressure in the production of the adhesive strip (29) is produced by the pressure roller (38) and a rubber pressure member (50) disposed in opposite relationship therewith, wherein the rubber pressure member (50) is in the form of a bar which extends in parallel relationship with the transverse rail (28) and which has roof-like inclined surfaces (51, 52).

8. Apparatus according to claim 7 characterised in that the contact line of the pressure roller (38) against the rubber pressure member (50) is on an inclined surface.

5            9. Apparatus according to one of claims 1 to 8 characterised in that the clamping means (5, 23, 24; 27) for clamping the material webs (3, 4) fast have a front (21), a central (5) and a rear clamping device (27), arranged in the direction of travel (9) of the material web (3, 4).

10           10. Apparatus according to one of claims 1 to 9 characterised in that the transverse rail (28) of the welding unit (30) and the clamping bars (7, 23, 24; 27) extending in parallel relationship with the transverse rail (28), or clamping beams of the clamping means, are set at an angle ( $\alpha$ ) relative to the direction of travel (9) of the material webs (3, 4) of 60° to 90°, preferably 70° to 80°, and particularly preferably 85°.